

ASAP

Dart Aerospace Ltd.

Date: Tuesday, 26/08/2008 7:28:44 AM
User: Linda Lacelle

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 41619 ~2			Part Number	: D33191		
Estimate Number	: 10437			Drawing Number	: D3319 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 26/08/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 02/09/2008		Qty: 12
Previous Run	: 39564			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est: B 05.10.14 Added step 9, dwg rev B KJ/EC			Est Rev:C Now on Waterjet 06-10-26 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048 Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s) 104921 x 6 = 4 1010/1025/A21/6aA SHEET .048 165084 x 7 = 5 Batch: 104921 1B 8-8-26
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B 1B 8-8-26 Prog Rev: B (B)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-8-26
4.0	QC8	SECOND CHECK Comment: SECOND CHECK 1B 8-8-26 (X/3)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary N/A Done at 06/08/26 12.2

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Seq. #:	Machine Or Operation:	Description :								
6.0	BRAKE NC	NC BRAKE								
		 Comment: NC BRAKE <p>1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>B</u> 2- Form flat on press using DT8776 block</p>								
7.0	QC5	DIMENSIONAL CHECK								
		 Comment: DIMENSIONAL CHECK <p><u>5</u> 08/08/28 (X4)</p>								
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1								
		 Comment: LARGE FABRICATION RESOURCE 1 <p>1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: <u>B</u></p> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>7560 Hardcoat Rod</td> <td><u>M106762</u></td> </tr> </tbody> </table> <p><u>E</u> 4-8-29</p>	Qty	Part Number	Description	Batch	A/R	N/A	7560 Hardcoat Rod	<u>M106762</u>
Qty	Part Number	Description	Batch							
A/R	N/A	7560 Hardcoat Rod	<u>M106762</u>							
9.0	QC10	VISUAL INSPECTION OF GROUND WELDS								
		 Comment: VISUAL INSPECTION OF GROUND WELDS <p><u>S</u> 08/08/29 (X4)</p>								
10.0	QC5	INSPECT WORK TO CURRENT STEP								
		 Comment: INSPECT WORK TO CURRENT STEP <p><u>S</u> 08/08/29 (X4)</p>								
11.0	POWDER COATING	POWDER COATING								
		 Comment: POWDER COATING <p>M106442 <u>4X</u></p> <p>Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3</p> <p>START TIME: <u>11:45</u> OVEN TEMPERATURE: <u>320° F</u> FINISH TIME: <u>12:15</u></p> <p><u>m-f</u> 08/09/02</p>								
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION								
		 Comment: INSPECT POWDER COAT <p><u>H2</u> 08 09-02 <u>(X4)</u></p>								

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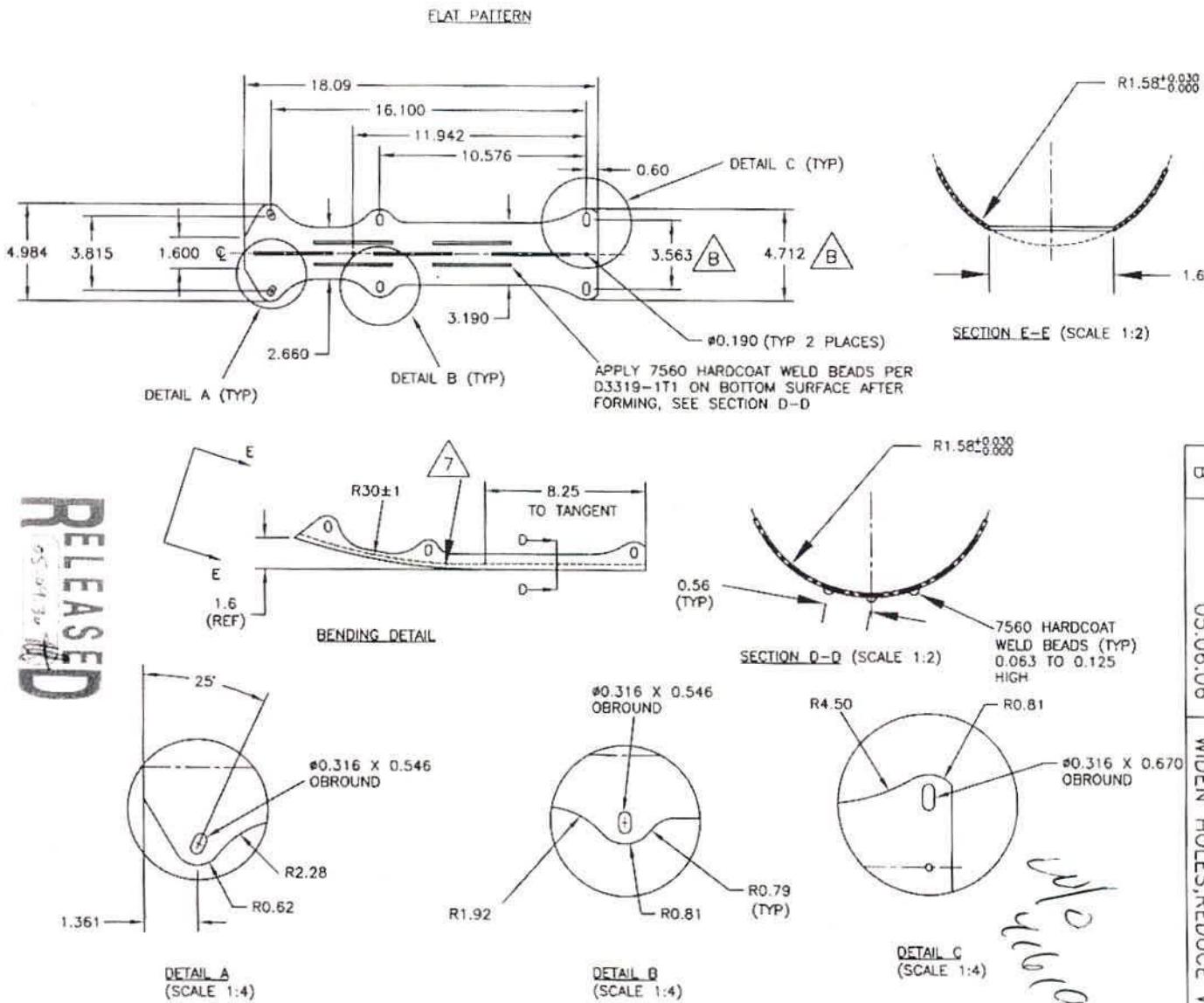
Seq. #:	Machine Or Operation:	Description :
13.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D33191-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: <i>796</i>
14.0	QC21	 Comment: FINAL INSPECTION/W/O RELEASE <i>slala</i> <i>SP</i> <i>4x</i> <i>08/09/02</i>

Job Completion:


u 28.09.02

DART

DESIGN	P1	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319
A	04.09.24	TITLE	WEARPLATE
B	05.06.06	SCALE	1:8

**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED